



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

APR 17 2018

D350-567-141
Job Sheet 176015



Part No: D350-567-141

Job Qty: 1 ea

Part Name: Floor Window Close Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/13/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER ECN12-511 DD
VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER DSI9590
REV:E DD VERF:JLM IPP REV:E AS PER DSI9590 REV F JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	1 Ea		4/27/18	0.00 0.00	Start Up Stores/Pkg-2	DAS 9-89	APR 27 2018
110	Packaging	1 pcs		4/27/18	0.00 0.00	Packaging1-3	6	APR 27 2018
120	QC	1 pcs		4/27/18	0.00 0.00	QC4	9-89	DAS 58
125	DC	1 pcs		4/27/18	0.00 0.00	DC	9-89	DAS 58
130	Packaging	1 pcs		4/27/18	0.00 0.00	Packaging3-1	9-89	DAS 58
140	QC21-FG	1 Ea		4/27/18	0.00 0.00	QC21	9-89	APR 27 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D350-567-141 CHG004
Descriptions: 130 - Identify and pack for shipping as per PPP D350-567-141 Location:FG033

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	7 Ea (7 ea)	90-Start up Operation	501528
AN525-10R6	Screw	2 Ea (2 ea)	90-Start up Operation	50137307
AN525-832R7	Screw	2 Ea (2 ea)	90-Start up Operation	5014745
D3802-1024	Window Seal (\$ Per Foot)	1x 2 Ea (2 ea)	90-Start up Operation	5015457
D4434-041	Fwd Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5064719
D4434-047	Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5061225
D4435-045	T/R Bellcrank Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5054124
D4435-9	Bracket	2 Ea (2 ea)	90-Start up Operation	5063147
D4436-041	Aft Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	50157347
D4441-1-024	Rubber Seal	1x 2 Ea (2 ea)	90-Start up Operation	50157347
MS21042L06	Nut	7 Ea (7 ea)	90-Start up Operation	50157347
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	50157347
MS21042L3	Nut	5 Ea (5 ea)	90-Start up Operation	5006902
MS21059L3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	5025740
MS35206-229	Screw	7 Ea (7 ea)	90-Start up Operation	50135603
NAS1149F0332P	Washer	12 Ea (12 ea)	90-Start up Operation	5057525
NAS1149FN616P	Washer	14 Ea (14 ea)	90-Start up Operation	5017371
NAS1149FN816P	Washer	2 Ea (2 ea)	90-Start up Operation	5017316-25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																				

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By

Root Cause <table> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td><td>Power Lo:</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td><td>Folio/Pro:</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong S:</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Se</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td></tr> </table>		Pressure/Forced	☐	Temperature/Cure	☐	Power Lo:	☐	Bending	☐	Set-up	☐	Folio/Pro:	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong S:	☐	Cuffs	☐	Contamination	☐	Out of Se	☐	Crushing	☐	Countersink	☐	Off-set	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐
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OTHER :																																																																																																															

Part: D350 - 567 - 141
 Job No: 176015
 Serial No/Batch: S065998
 Revision:
 Inspector:



DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 832-6200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 04/27/16

90-Start up Operation

AN3-3A	7	791	0
AN525-10R6	2	246	0
AN525-832R7	2	60	0
D3802-1	2	69	0
D4434-041	1	2	0
D4434-047	1	2	0
D4435-045	1	5	0
D4435-9	2	8	0
D4436-041	1	2	0
D4441-1	2	143	0
MS21042L06	7	363	0
MS21042L08	2	2,691	0
MS21042L3	5	2,443	0
MS21059L3	2	219	0
MS35206-229	7	53	0
NAS1149F0332P	12	3,115	0
NAS1149FN616P	14	93	0
NAS1149FN816P	2	250	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002861	S065995	AN3-3A	Bolt	s015688	ST350	7
002861	S065994	AN525-10R6	Screw	fm137307	ST329	2
002861	S065993	AN525-832R7	Screw	s014745	ST328	2
002861	S065992	D3802-1	Window Seal (\$ Per Foot)	s015457	ST416	2
002861	S065991	D4434-041	Fwd Bracket Assembly	s064719	ST623	1
002861	S061225	D4434-047	Cover Assembly	S062278	ST619	1
002861	S022224	D4435-045	T/R Bellcrank Cover Assembly	F161204	ST620	1
002861	S054124	D4435-9	Bracket	S054125	ST091	2
002861	S065989	D4436-041	Aft Bracket Assembly	s063147	ST618	1
002861	S065988	D4441-1	Rubber Seal	f151347	ST422	2
002861	S065987	MS21042L06	Nut	s019379	ST303	7
002861	S065986	MS21042L08	Nut	s044234	ST303	2
002861	S065985	MS21042L3	Nut	s006902	ST303	5
002861	S065984	MS21059L3	Nut Plate	s025740	ST301	2
002861	S065983	MS35206-229	Screw	fm135603	ST271	7
002861	S065982	NAS1149F0332P	Washer	s057525	ST262	12
002861	S065981	NAS1149FN616P	Washer	s019371	ST264	14
002861	S065980	NAS1149FN816P	Washer	f117316-25	ST263	2

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/27/18 8:19 AM dart.quirion.sonia

Change Record

PAGE 1 OF 1

Part Number: D350-567-141

Description: FLOOR WINDOW CLOSEOUT

[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : ☐			

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

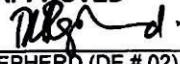
4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	